

Date: Tuesday, 1/8/2008 1:19:21 PM  
 User: Kim Johnston

## Process Sheet

5

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L BASKET LID  
 Job Number : 36655B  
 Estimate Number : 11274  
 P.O. Number :  
 This Issue : 1/8/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2252043  
 Drawing Number : D2252 REV E  
 Project Number : N/A  
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : E  
 Previous Run : 36654B Material :  
 Due Date : 1/31/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 08.01.08  
 Comment : Est Rev.1 REVISED AS PER REV E 05-12-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s) M108063 = 32.55  
 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M108153

SAD 08/06/17 (1)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2252-1-3-9 as per Dwg D2252 SAD 08/06/17 (1)  
 2-Drill hole in D2252-1 as per Dwg D2252  
 3-Deburr & Remove all Markings from Material

3.0 D2329 Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2329 Label Plate B35686

FC 08 06 24

4.0 D23271 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2327-1 Bushing B36920

FC 08 06 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/8/2008 1:19:21 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 36655B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

HINGE

D35684

✓

FC 08 06 29

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Chancel

D39046

✓

FC 08 06 29

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M108152

✓

SAP 08/06/24

①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD

Batch: M105524

FC 08 06 25

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/06/26

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/26

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

24

08-06-22

S.028

#1

#2

#3

#4

4000F  
D2252043  
133662508  
27/06/2008

08.11

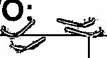
40.3 F

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3000 F

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**Dart Aerospace Ltd**

W/O: 		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 1/8/2008 1:19:22 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 36655B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BK 08-06-27*

*①*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *G-A*

*EP 08/07/01 @*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/03 HJ*

Job Completion



*MF 08-07-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



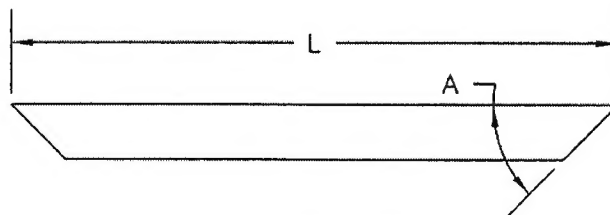
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CHECKED #	APPROVED #	DRAWING NO. D2252	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

RELEASED  
05.11.26

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.





CUT SIZE DETAIL

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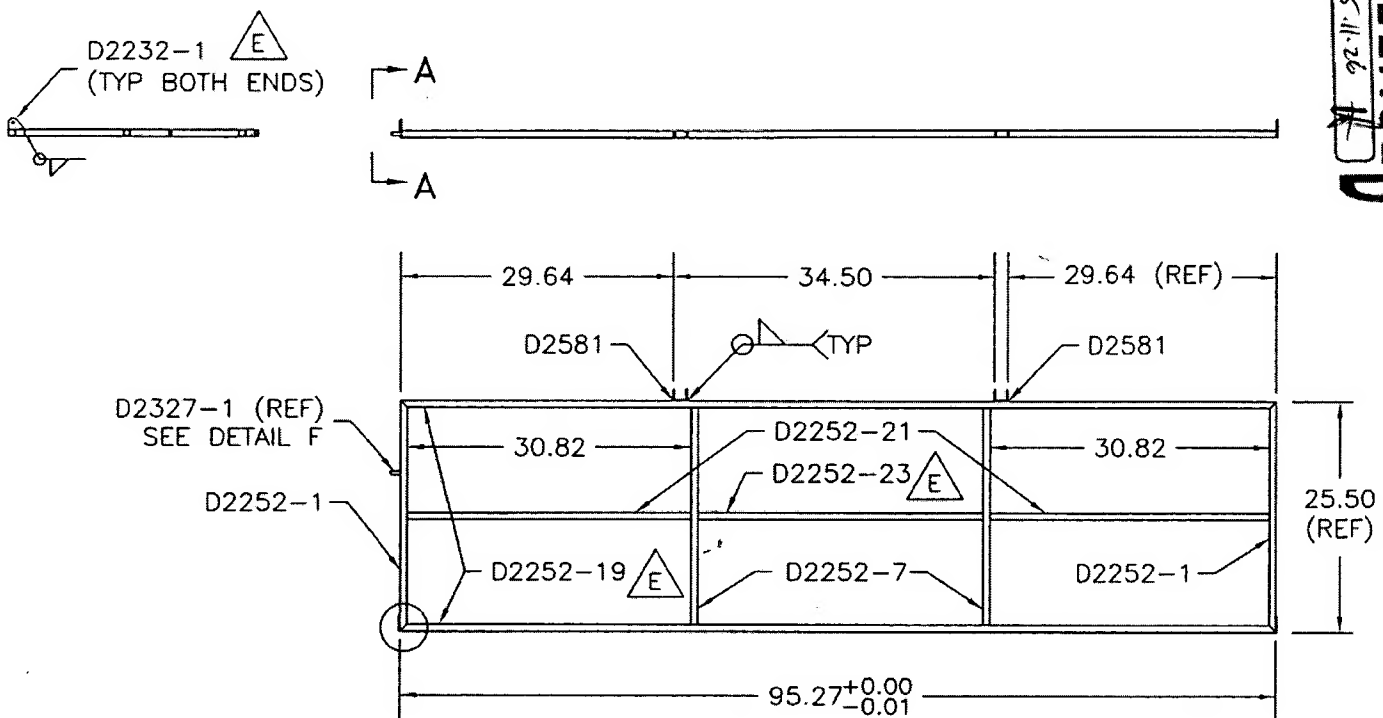
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CHECKED 	APPROVED 	D2252	SHEET 2 OF 5
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SCALE NTS	

**RELEASED**  
05.11.26



D2252-043 LID FRAME

TYP TYP

WELD ALL JOINTS  
AS SHOWN

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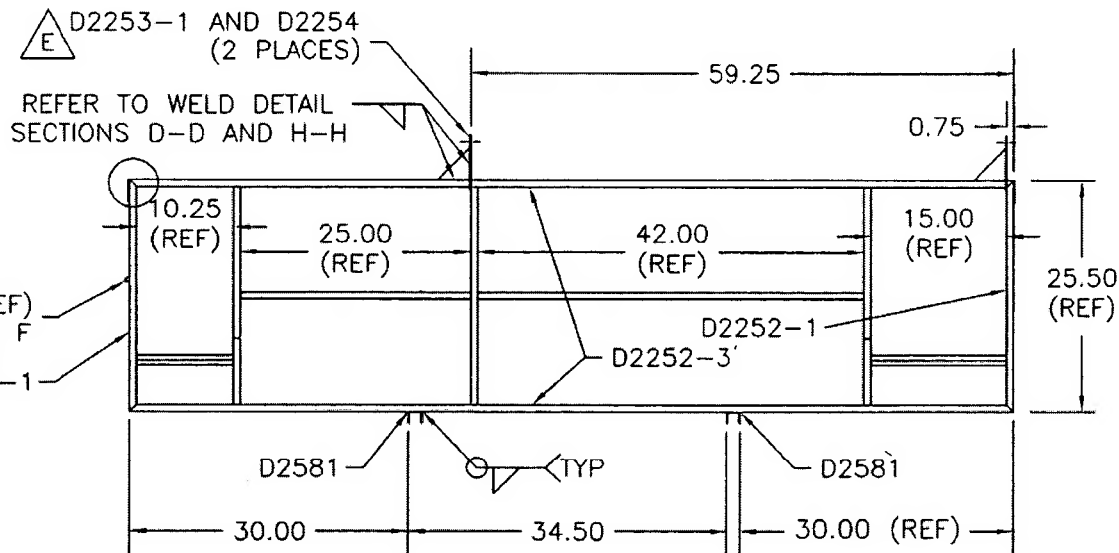
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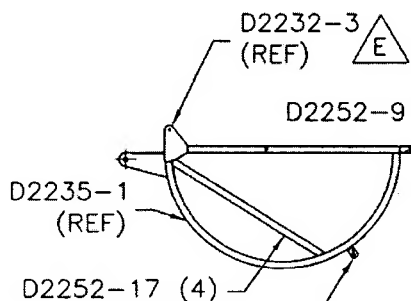




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DATE	05.11.10	TITLE	BASKET ASSEMBLY (206L)	REV. E SHEET 3 OF 5
		SCALE	NIS	



WELD ALL JOINTS  
AS SHOWN



WELD D2581  
WITH LARGE HOLE  
ON THIS SIDE

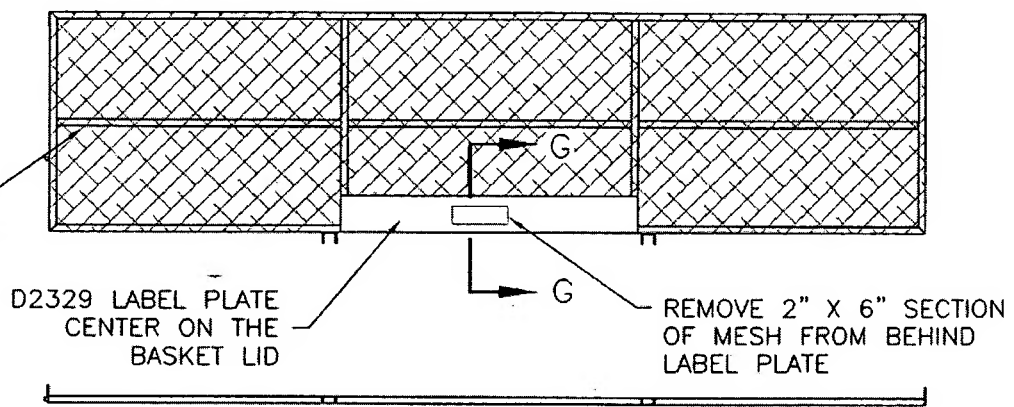
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D2252-041 BASKET FRAME

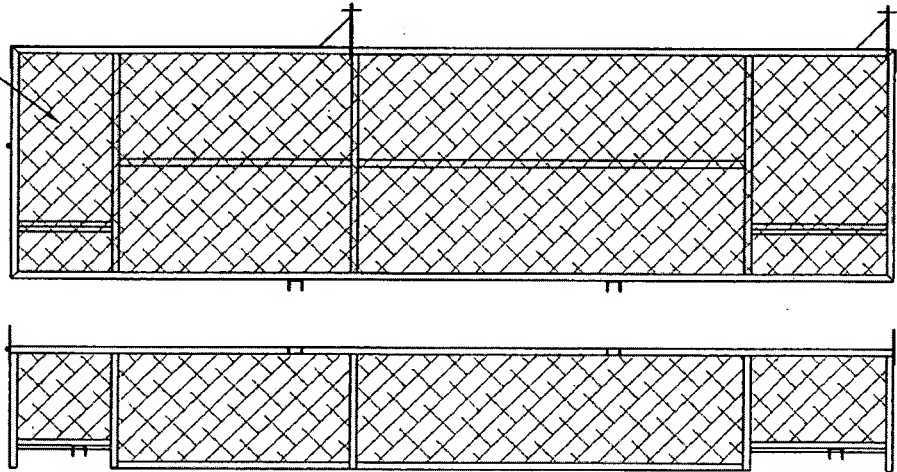
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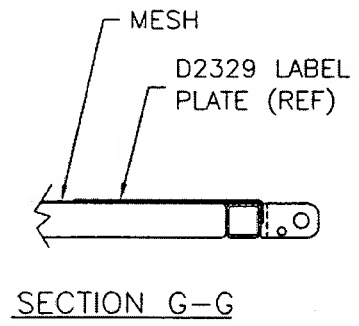
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DATE	05.11.10	TITLE	BASKET ASSEMBLY (206L)	REV. E SHEET 4 OF 5 SCALE MKS



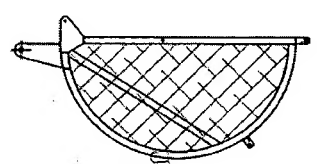
D2252-043 LID ASSEMBLY



D2252-041 BASKET ASSEMBLY



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME

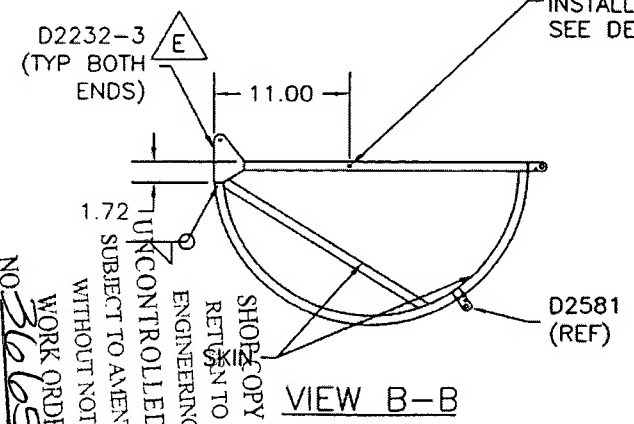
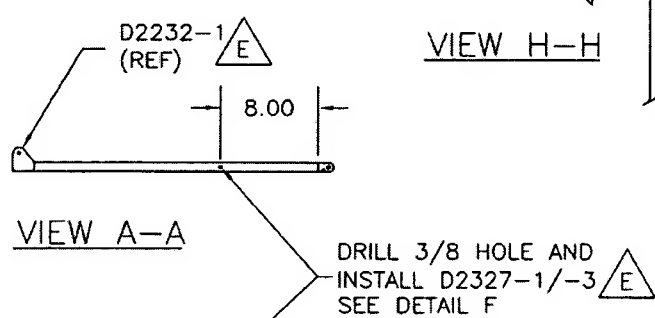
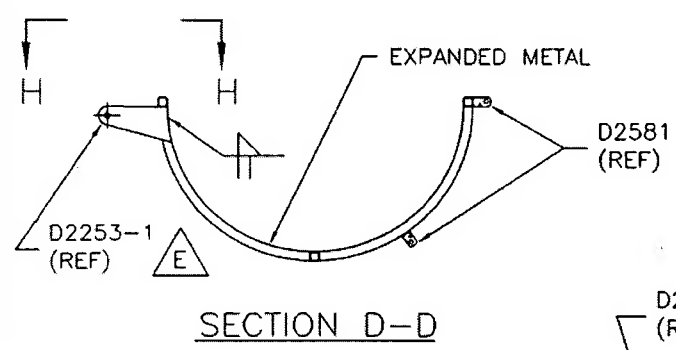
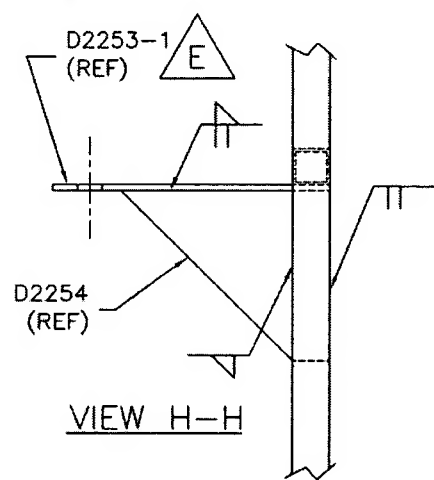
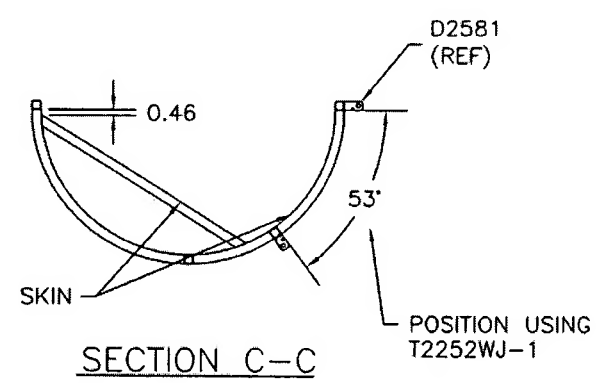
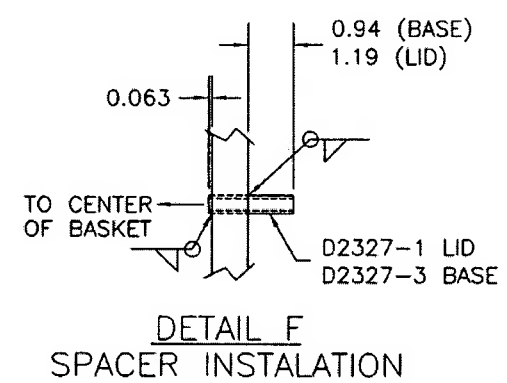
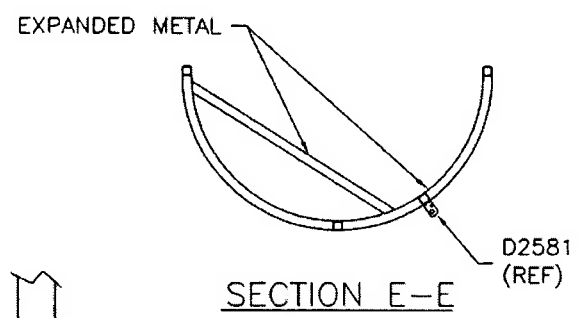


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KE	MB	DRAWING NO.	D2252	REV. E
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DATE	05.11.10			SCALE
				NTS



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WORK ORDER  
NO 366557B

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